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**Abstract of the Disclosure**

A scanning system which scans for defects in decorative panels by generating images of the panels. A comparative program, i.e., recipes of samples of decorative panels having defect types and degrees, enables the system to make  
5 comparisons of defects and through said comparisons to grade the defects whereby the panels are graded as, *e.g.*, acceptable, re-work, shop or reject. The program is modified for different decorative wood species and a controller dictates the comparative program to be applied for different customer orders of decorative wood panels.